

Date: Thursday, 12/15/2005 3:55:50 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR ASSEMBLY
Job Number	: 25254		
Estimate Number	: 10713		
P.O. Number	: N/A	Part Number	: D3213041
This Issue	: 12/15/2005 S.O. No. : N/A	Drawing Number	: D3213 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL / MED FAB	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE ABOVE DATE &amp; USER.</u>	Due Date	: 1/5/2006 Qty: 10 Um: Each
Checked & Approved By	: <u>SEE ABOVE DATE &amp; USER.</u>		
Comment	: Est Rev:A New Issue 05-11-17 17:27		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31613	Hinge 15.0"
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
2 D3161-3	Hinge	B24164 (10) B23189 (9)
		B24208 (5)

JAD 06/01/11 12

2.0	D32131	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
1 D3213-1	Door	B25260

3.0	D32133	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
1 D3213-3	Door	B25261

4.0	MS20470AD44	Rivet, Universal Head
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Comment: Qty.: 24.0000 Each(s)/Unit Total: 240.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
24 MS20470AD4-4	Rivet	M18729

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/15/2005 3:55:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 25254

Part Number: D3213041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3213 Identify as D3213-041

*SB 06/01/23*  
*ml 06/01/23*

12  
(12)

6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*Joe 07-24*

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*m 06-02-07* 12

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*DL 06/02/09* 12

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5792*

*06/2/13 (12)*

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

*545 06/02/14 (12) (12) 06/02/14 (12)*


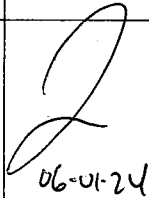
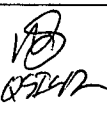
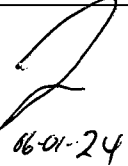
Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 1 2 Date: 06/01/24

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/01/24	5	<del>Change</del> change 1 Hinge hole out of Tolerance		remove + replace	SB 06/01/24	 06-01-24		 06-01-24

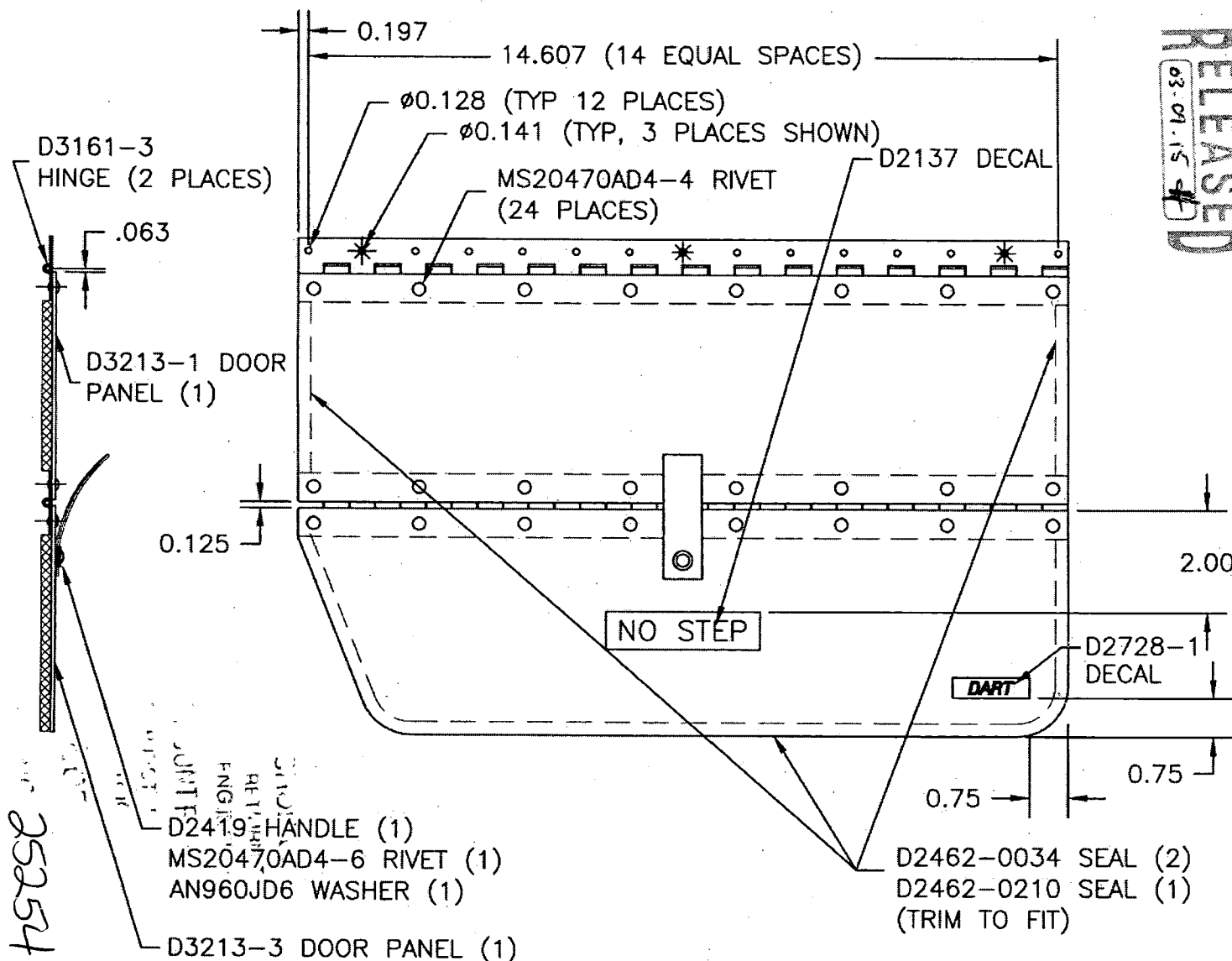
NOTE: Date & initial all entries

**DART**



DESIGN	DRWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3213
DATE 03.09.03	TITLE DOOR ASSEMBLY	REV. A 1 OF 2
A	03.09.03	SCALE 1:3
	NEW ISSUE	

RELEASED  
03-01-15



# **D3213-041 DOOR ASSEMBLY**

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

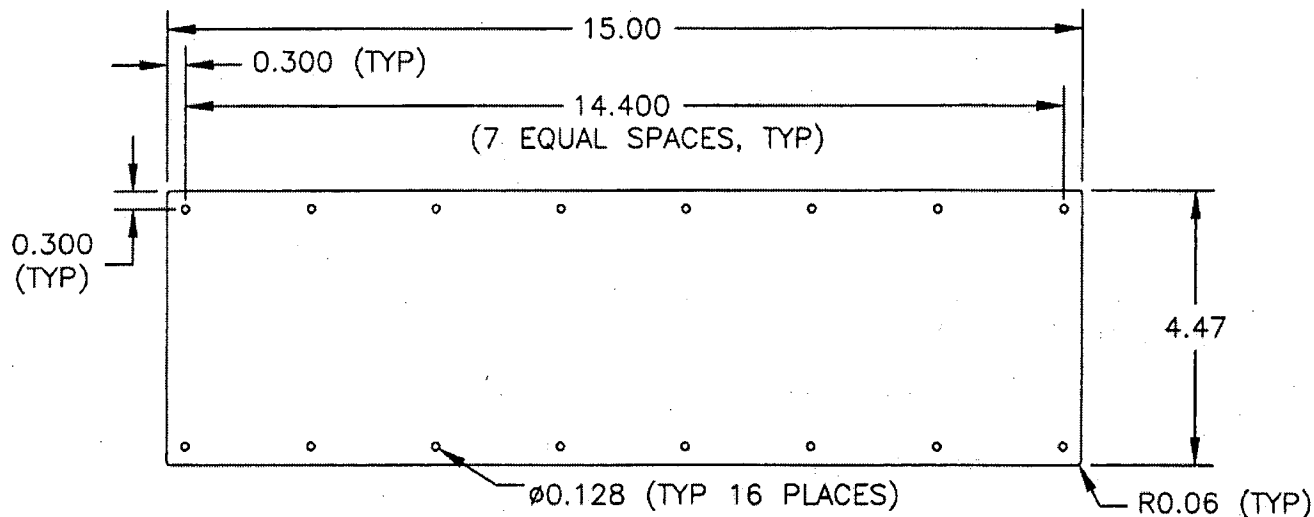
INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

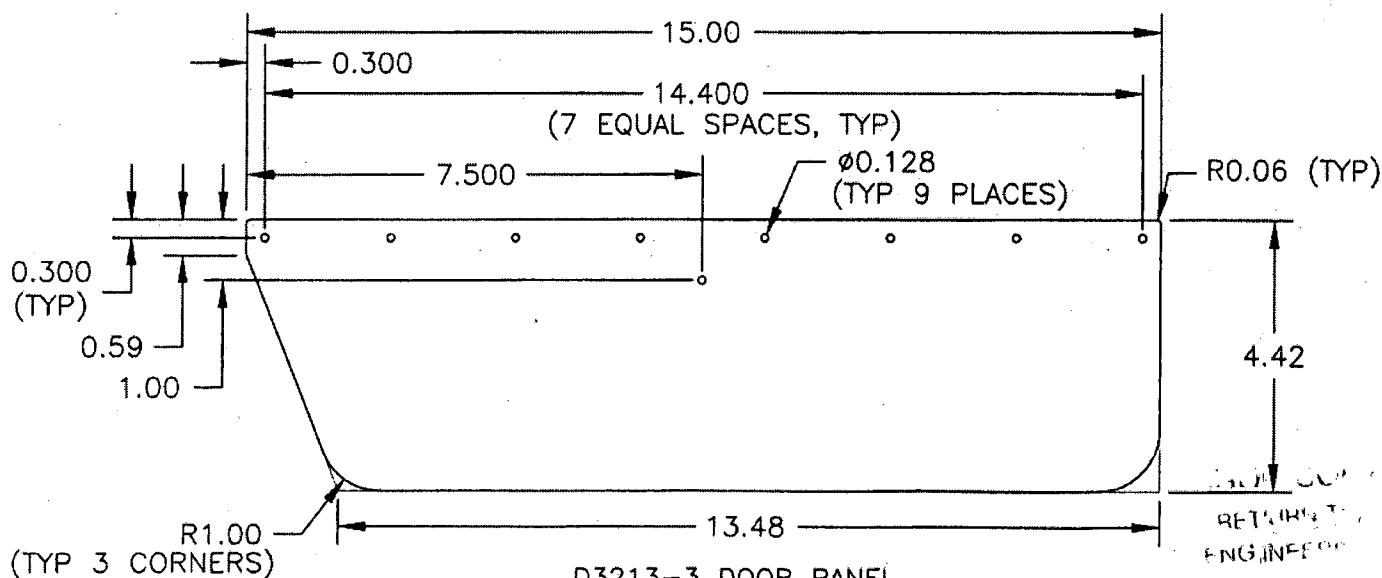
25254



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
03.09.15

25254

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Date: Tuesday, 2/7/2006 11:26:32 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	DOOR ASSEMBLY
<b>Job Number</b> :	25254		
<b>Estimate Number</b> :	10713		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3213041
<b>This Issue</b> :	2/7/2006	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3213 REV A
<b>First Issue</b> :	12/15/2005	<b>Project Number</b> :	N/A
<b>Previous Run</b> :		<b>Drawing Revision</b> :	A
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :		<b>Due Date</b> :	1/5/2006
<b>Comment</b> :	Est Rev:A New Issue 05-11-17 17:27	<b>Qty:</b>	10 Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D31613	Hinge 15.0"
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
2 D3161-3	Hinge	

*see 1st page*

2.0	D32131	Door Panel
-----	--------	------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
1 D3213-1	Door	

3.0	D32133	Door Panel
-----	--------	------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
1 D3213-3	Door	

4.0	MS20470AD44	Rivet, Universal Head
-----	-------------	-----------------------



**Comment:** Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
24 MS20470AD4-4	Rivet	

Date: Tuesday, 27/2006 11:26:32 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 25254

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3213 Identify as D3213-041

*sell*  
*1st page*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Decal - No Step

*B24358*

10.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Handle

*B24394*

11.0

D2462

Neoprene Seal



Comment: Qty.: 2.1500 f(s)/Unit Total : 21.5000 f(s)

Neoprene Seal

*B22749*

12.0

D27281

Dart Logo label small



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Dart Logo label small

*B24215*



Date: \* Tuesday, 2/7/2006 11:26:32 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 25254

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
Washer

M6085

14.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
Rivet, Universal Head

M18615

SAD 06:02:08

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
ASSEMBLE PER DRWG D3213

DL 06/02/09

(12)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

Job Completion



16.1 QCS

I inspect Wentz To Current Step.